

Date: Thursday, 29/01/2009 3:20:12 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 45368C			Part Number	: D2221		
Estimate Number	: 10189			Drawing Number	: D2221 REV H		
P.O. Number	:			Project Number	: N/A		
This Issue	: 29/01/2009	S.O. No.	:	Drawing Revision	: H		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 05/02/2009		Qty: 1 Um: Each
Previous Run	: 45359C						
Written By	:						
Checked & Approved By	: JUP 09.01.29						
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC Est Rev:M 08-12-02 revH as per dwg DD verified by:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22211	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: B 44864 → 1x	
2.0	D22215	Rib	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: B 44752 → 2x	
3.0	D22217	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: B 44753 → 1x	
4.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge batch: B 44075 → 2x	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

Date: Thursday, 29/01/2009 3:20:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BASKET BASE ASSEMBLY (350)
Job Number:	45368C	Part Number: D2221
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D22351	Basket Rib
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Rib batch: B 45227 → 2		SL 09/02/04
6.0	D2581	Mounting Bracket
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket batch: B 43800 → 2x		SL 09/02/04
7.0	D34421	Shim
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Shim batch: B 40392 → 2x		SL 09/02/04
8.0	D3825041	Rib Assembly (Basket End)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib Assembly (Basket End) batch: B 44755 → 2x		SL 09/02/04
9.0	D3826041	Rib / Gusset Assembly
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib / Gusset Assembly batch: B 44756 → 2x		SL 09/02/04
10.0	D3827041	Rib Assembly (Inboard)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib Assembly (Inboard) batch: B 44011 → 1x		SL 09/02/04
11.0	D38331	Mesh (Base End Face)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mesh (Base End Face) batch: B 44764 → 2x		SL 09/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

Date: Thursday, 29/01/2009 3:20:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45368C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: 344765 → W

SJ 09/02/05

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108775

SJ 09/02/05

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 09-02-09

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/02/05 (P)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M109996

1ST COAT:

START TIME: 13:00

OVEN TEMPERATURE: 400°

FINISH TIME: 14:20

***** 2nd coat if necessary *****

(P)

PL 09-02-11

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Date: Thursday, 29/01/2009 3:20:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45368C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 09/02/12 ①

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/13 ②

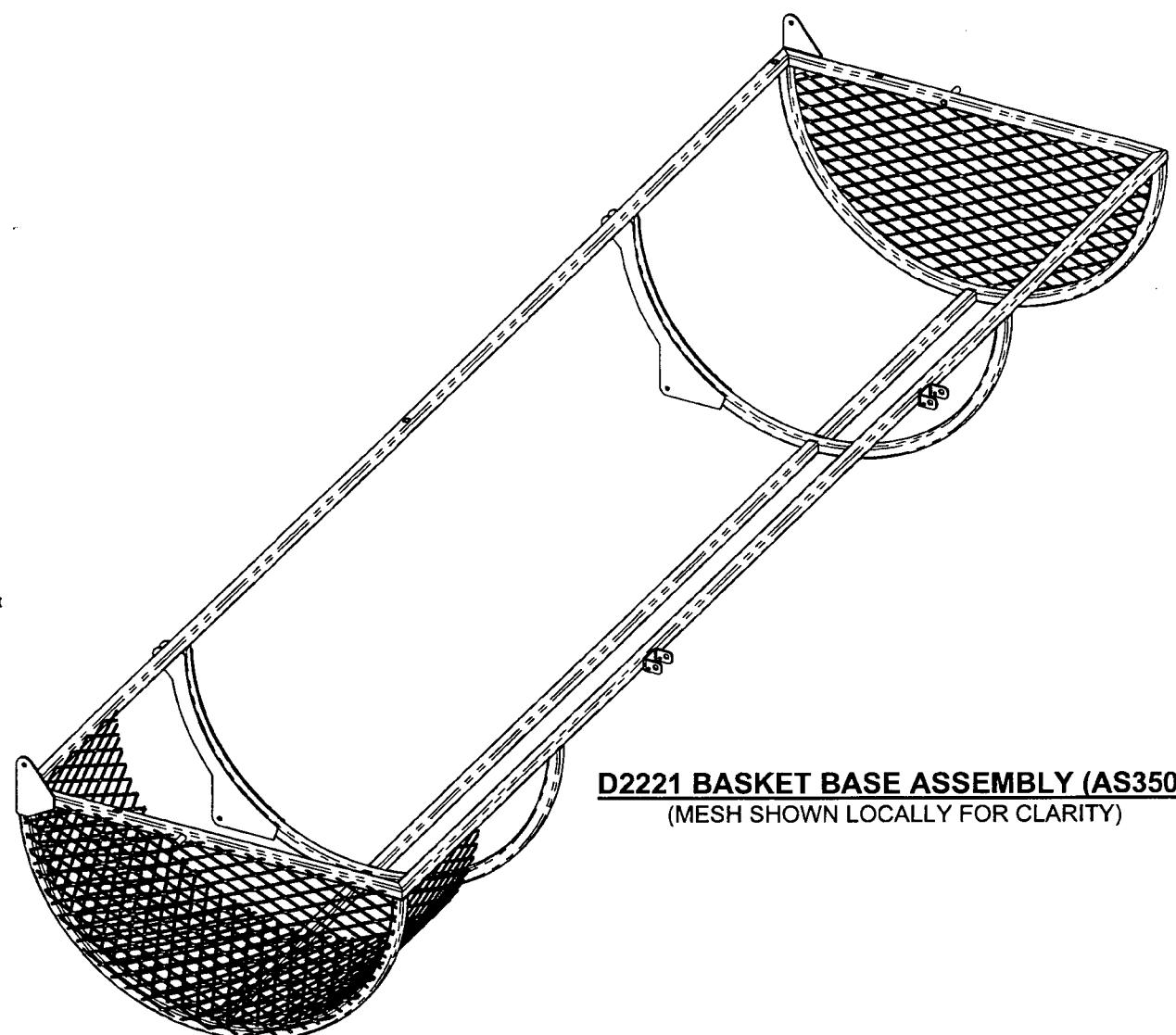
Job Completion



u 09.02.13

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)



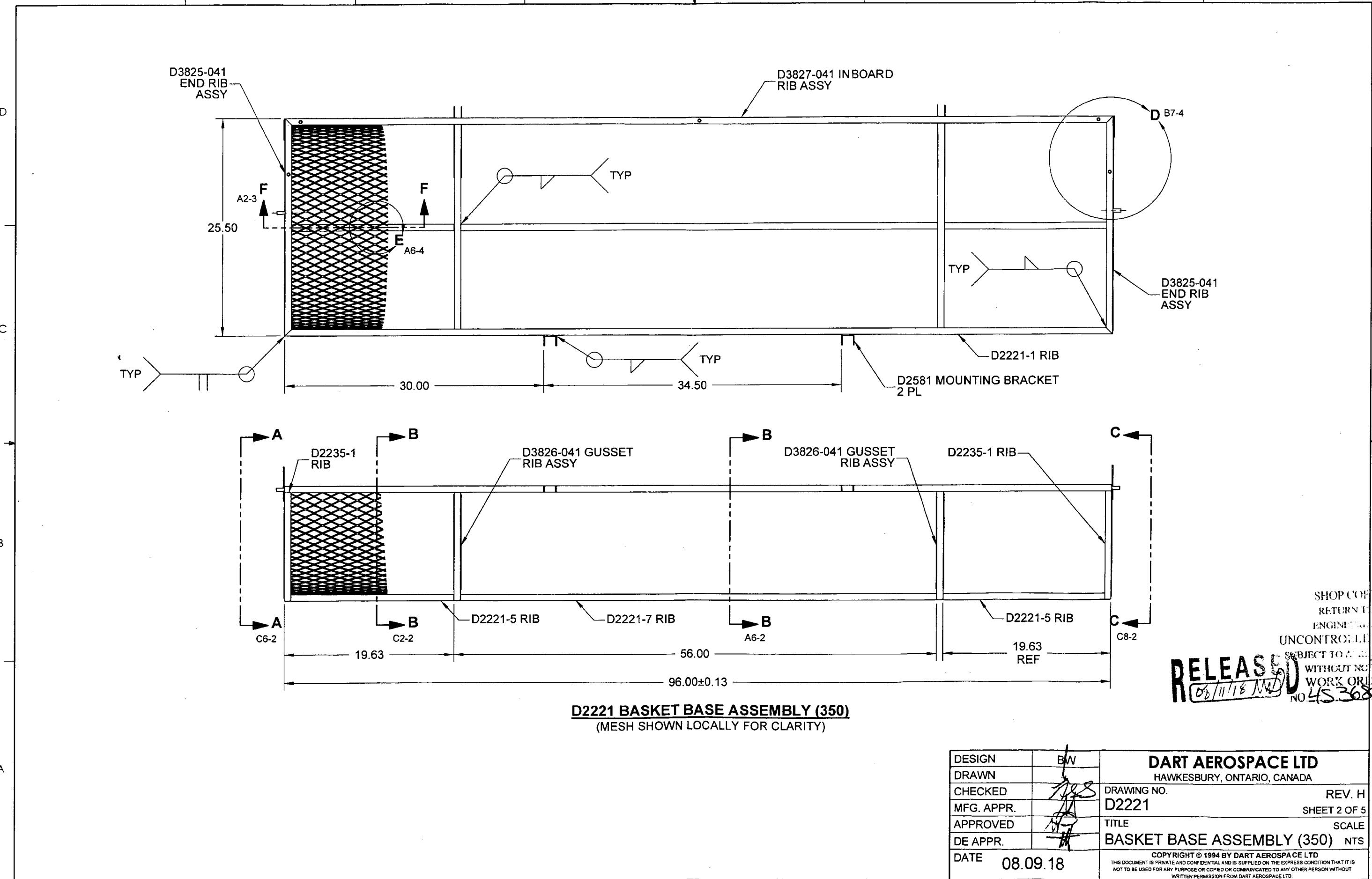
D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

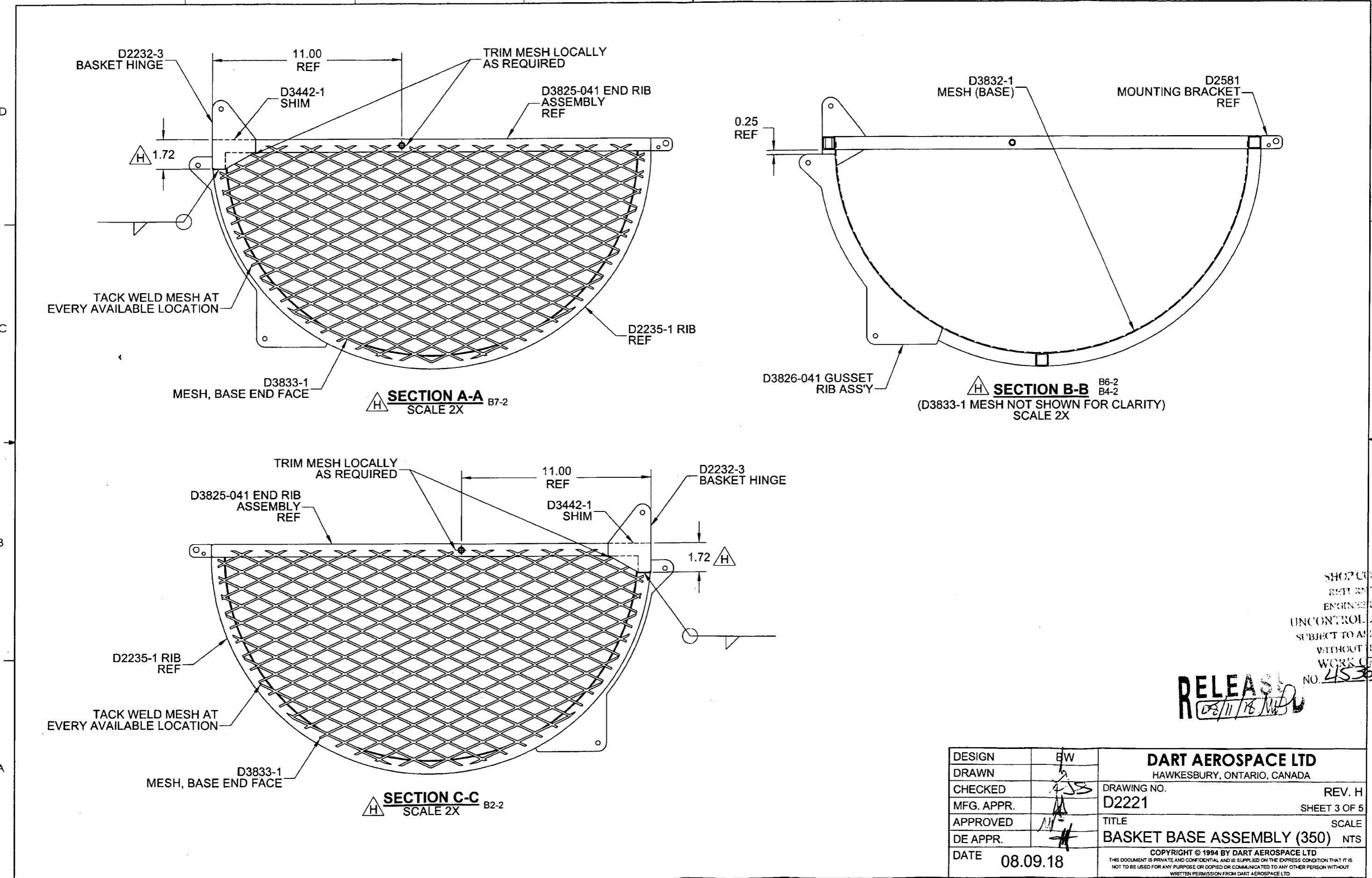
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 42.00 lbs APPROX
 - 8) MASK ALL HOLES PRIOR TO POWDER COATING

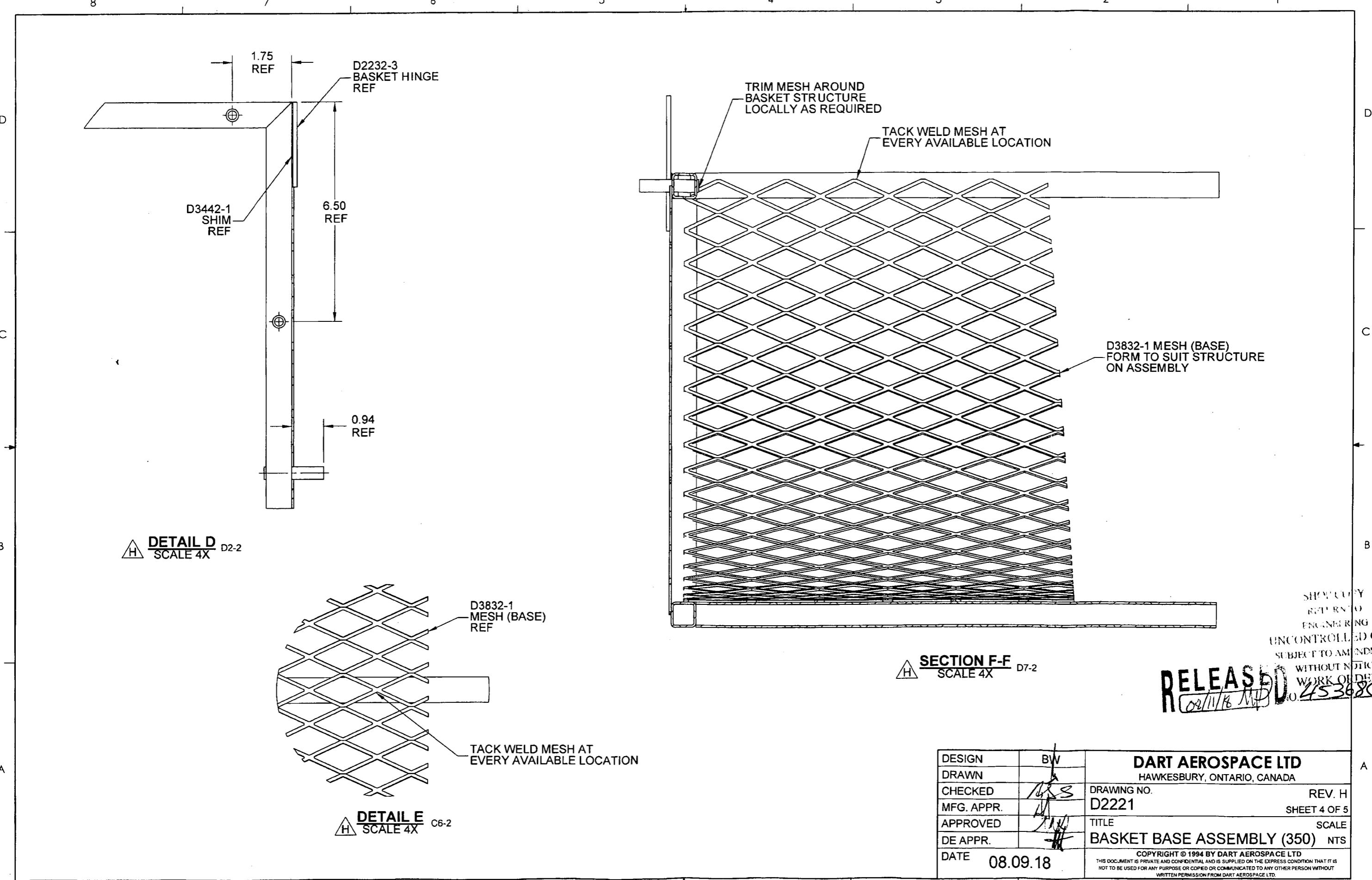
RELEASED
08/11/18
N/HS369C
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	✓	DRAWING NO. D2221 REV. H	
CHECKED	✓	SHEET 1 OF 5	
MFG. APPR.	✓	TITLE	
APPROVED	✓	SCALE	
DE APPR.	✓	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



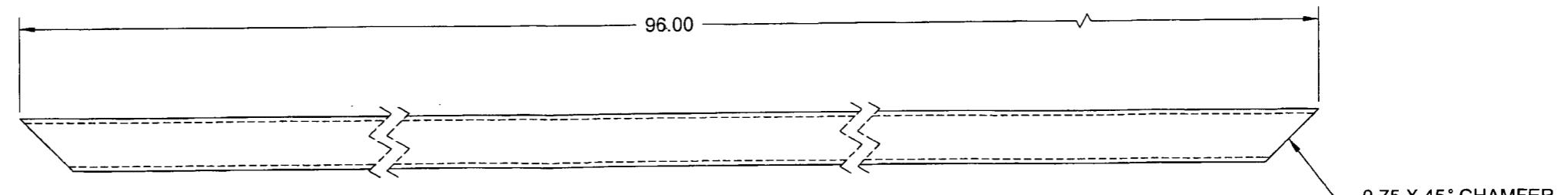
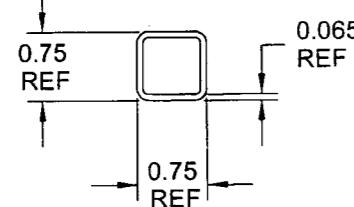




8 7 6 5 4 3 2 1

D

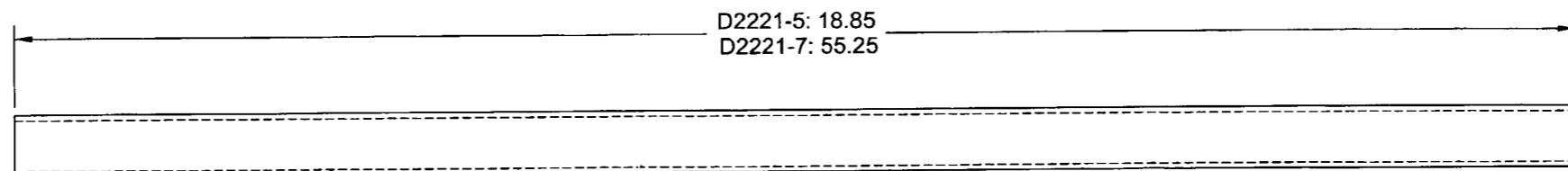
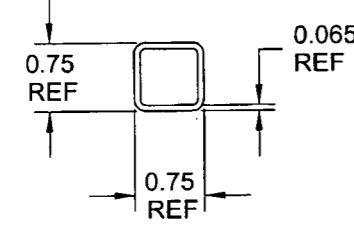
D



△ H D2221-1 RIB

C

C



△ H D2221-5/-7 RIB

B

B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45368C

RELEASED
08/11/18/W

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	
MFG. APPR.	ND	REV. H	
APPROVED	JW	D2221	
DE APPR.	JK	TITLE	
DATE	08.09.18	SCALE	
BASKET BASE ASSEMBLY (350) NTS		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			